

5166214



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE1X25-166-856-1
Job Sheet 189524



Part No: RBE1X25-166-856-1

Job Qty: 6 pcs

Part Name: Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/25/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1X25-166-856 Rev.1 IPP Rev. A 19.01.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	QC 2	6 pcs	2/28/19	2/28/19	0.00	6.00	Man. set: TL-40-1		66 2019-03-26
		6 pcs	2/28/19		0.00	0.00	QC 2 - 1		9-89
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

Plex 1/25/19 12:44 PM Dart.lajeunesse.marie

1/25/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 8	6 pcs	2/28/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
130 Packaging 3-1 - Stock - B4B	6 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	CL
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
140 QC 21 - SA	6 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21	
Part Op 100 - 1-Machine as per folio FC <u>631</u> FOLIO REV: _____ DWG REV: _____ 2-Deburr					
Descriptions: 130 - .					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6T4.250XW.375	6061-T6 Tubing Round, 4.250" OD X 0.375" Wall	6.7500 ft (1.125 ea)	100-NLX 2500SY - 1		
		1,438 ea	DEL		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-NLX 2500SY - 1	M6061T6T4.250XW.375	7	0	0	
Part Specifications					
Specifications could not be found.					

DAS
40
9-89

MAR 26 2019

CL

1,438 ea

DEL

DART
AEROSPACEDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 1/25/19 12:44 PM Dart.lajeunesse.marie

Container No: S166214



Part: RBE1X25 - 166 - 856 - 1

Job No: 189524

Serial No/Batch: S166214

Revision: B

Inspector:

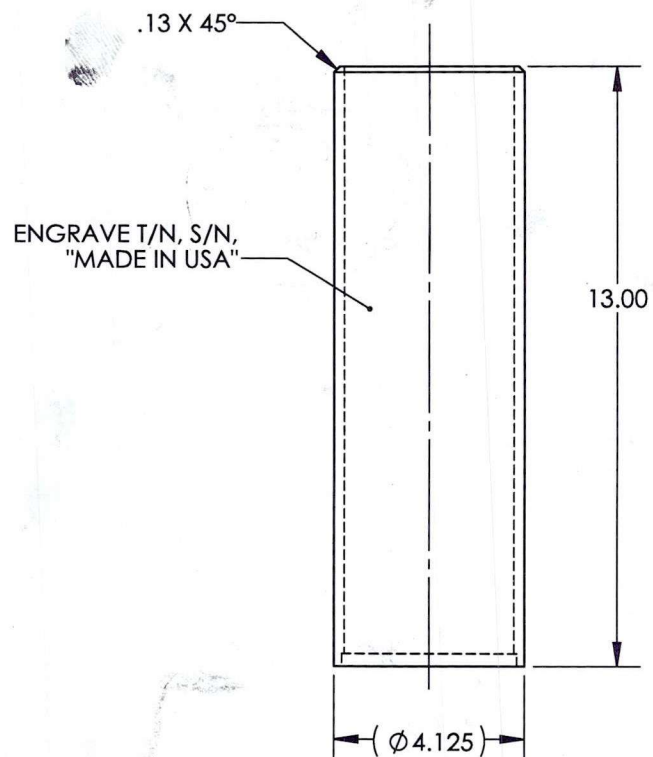
Exp Date:

Instructions:

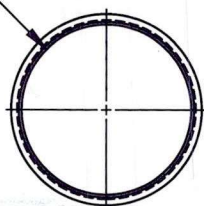
Date: 03/26/19

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	-1 MODIFIED END TO ACCEPT -5 END CAP FOR WELDMENT.	5/16/2014	JAG
			APPROVED
			GE



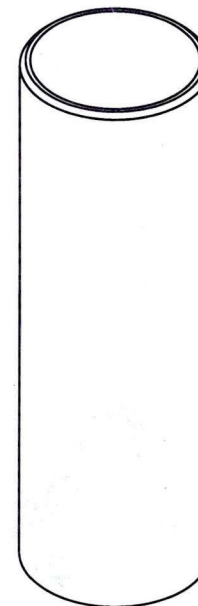
Ø 3.670^{+.005}_{-.000} THRU ALL
 Ø 3.7917
 Ø 3.7908 ± .275^{+.005}_{-.000}



(-1)

TUBE

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 189524 MJS
 1901-25



RED BARN MACHINE	
TITLE ADAPTER 856	
DWG NO. RBE1X25-166-876-1	REV 1
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH SEE -1
X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	EC135
SCALE 1:4	DATE 6/15/2012 SHEET 2 OF 5

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

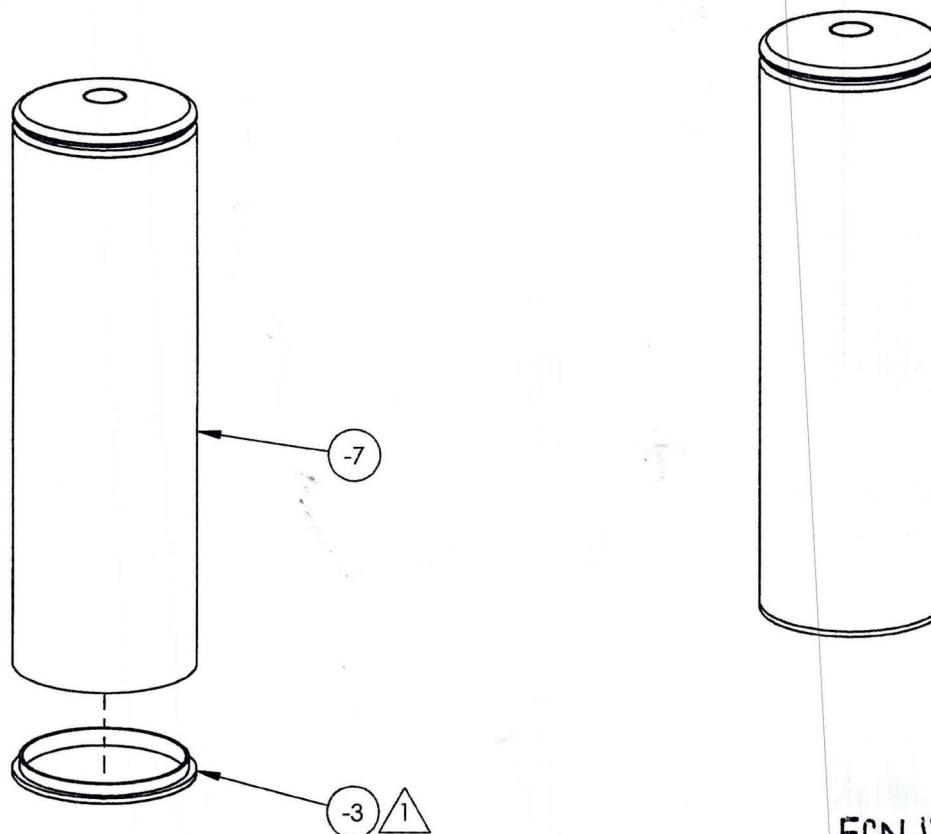
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-1 MODIFIED END TO ACCEPT -5 END CAP FOR WELDMENT. -5 ADDED CAP. -7 ADDED WELDMENT.	5/16/2014	JAG	GE
B	LOCTITE NOTE ADDED	1/30/2019	VM	VM



1. APPLY LOCTITE 495 BETWEEN THE SURFACES OF ITEM -3 AND ITEM -7 AND REMOVE EXCESS
2. REF. EUROCOPTER T/N: 1X25 166 856.
3. USED IN KIT RBEA62316.

ECN 19-541



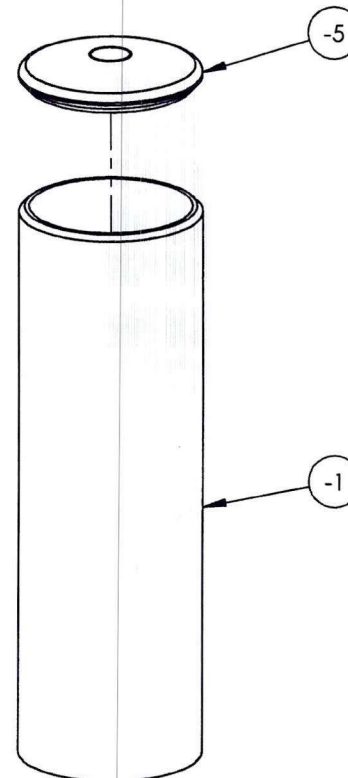
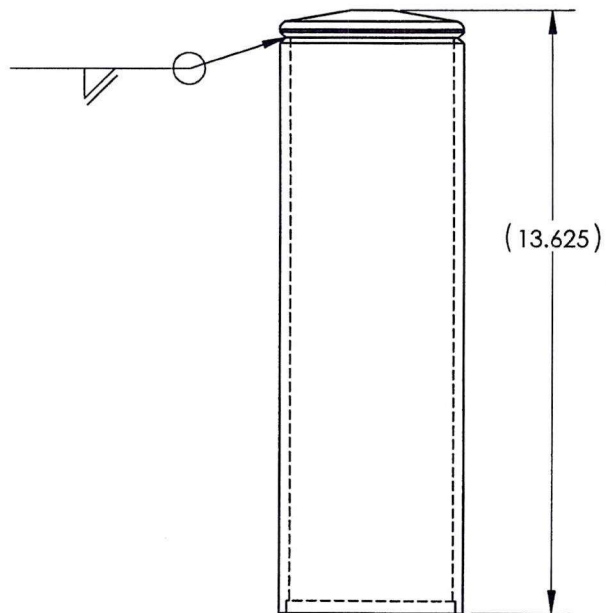
RED BARN MACHINE

TITLE		ADAPTER	
DWG NO.		RBE1X25-166-856	
REV		B	
MAT'L		DRAWN BY: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005 FRACTIONS ± 1/32		HEAT TREAT	
.XX ± .01 ANGLES ± 5°		FINISH	
X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		EC135	
SCALE	1:4	DATE	6/15/2012
		SHEET 1 OF 5	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	1		-1		TUBE	6061	Ø4-1/4 X 3/8 WALL X 13-1/8	2
			-3	1	INSERT	WHITE NYLON / DELRIN	Ø4-1/4 X 1/2	3
	1		-5		CAP	6061	Ø4-1/4 X 1	4
	X		-7	1	WELDMENT			5
	ASSY -7							

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-7 ADDED WELDMENT.	5/16/2014	JAG	GE

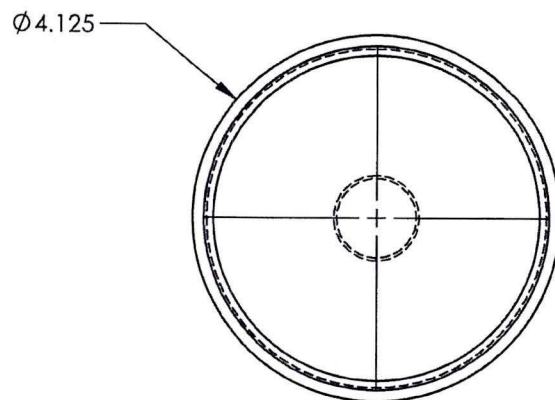
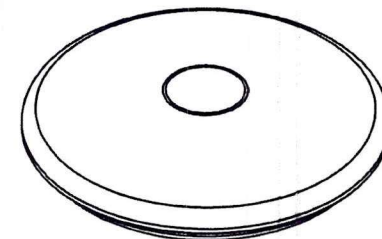
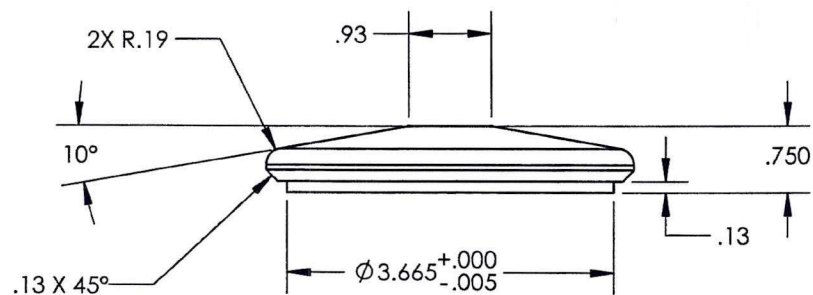


(-7)
WELDMENT

RED BARN MACHINE	
ADAPTER	
DWG NO. RBE1X25-166-876-7	REV B
MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	CLEAR ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS I
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EC135
SCALE 1:4	DATE 5/15/2014
SHEET 5 OF 5	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-5 ADDED CAP.	5/16/2014	JAG	GE

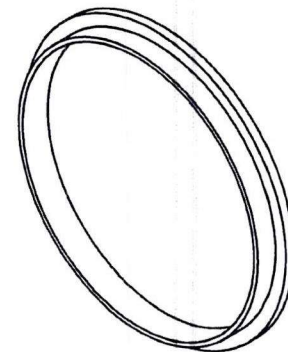
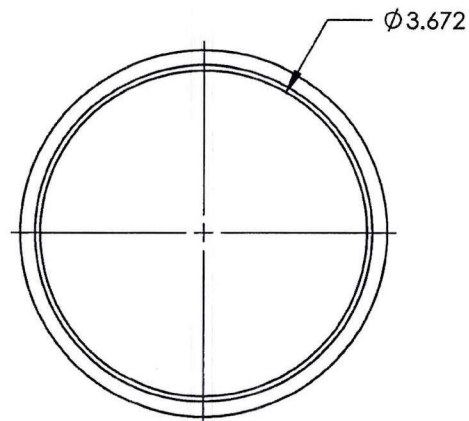
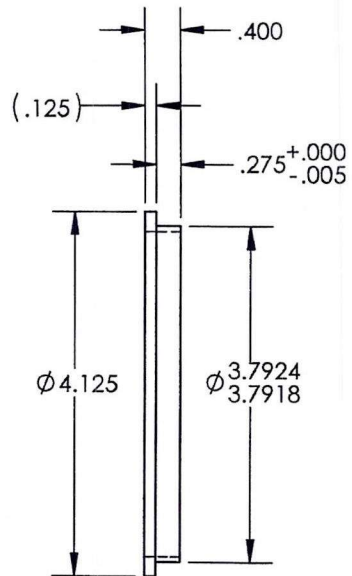


(-5)
CAP

RED BARN MACHINE	
TITLE ADAPTER	
DWG NO. RBE1X25-166-876-5	REV B
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weid</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH SEE -1
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	EC135
SCALE 1:2	DATE 6/15/2012
SHEET 4 OF 5	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



(-3)
INSERT

RED BARN MACHINE	
ADAPTER	
DWG NO.	RBE1X25-166-856-3
MAT'L WHITE NYLON / DELRIN	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	EC135
SCALE 1:2	DATE 6/15/2012
SHEET 3 OF 5	